

Date: Tuesday, 7/1/2008 10:45:09 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 40148		Part Number	: D2012111		
Estimate Number	: 10106		Drawing Number	: D2012-111 REV. A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 7/1/2008	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 7/20/2008		
Previous Run	: 38936		Qty:	40	Um:	Each
Written By	:					
Checked & Approved By	:					
Comment	: Est: C 00.05.02 Now laser cut EC est D 07.01.24 waterjet EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0226 sf(s)/Unit Total : 0.9030 sf(s) 304/316 Stainless Steel .063 Sheet Batch: 107675 FB 8-7-18		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2012-111 Dwg Rev: A FB 8-7-18 Prog Rev: A		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE FB 8-7-18		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 49 <i>counters</i>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary. FB 8/07/25 49		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 40148

Part Number: D2012111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/08/08 (49)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 578

C 8/1/28 (49)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/08 (49)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40148
Description: Bracket	Part Number:	D2012-111
Inspection Dwg: D2012- Rev: & A	(P08.07.01)	Page 1 of 1

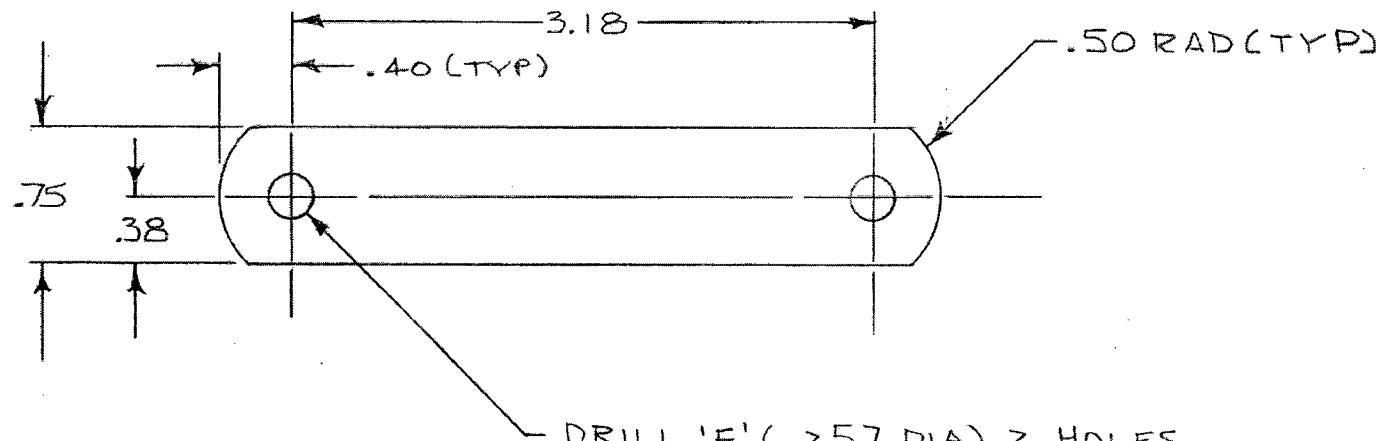
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

92/1

Measured by:	HB	Audited by:	J	Prototype Approval:	N/A
Date:	8-7-18	Date:	8/7/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.02.09	New Issue	KJ/JLM	<i>[Signature]</i>



WORK ORDER NO. 40148
 ENGINEERING COPY
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 SHOP COPY
 RETURN TO

NOTES: 1. MAT'L AISI 304/316 CRES
.063 THICK



D2012-111

	A	REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523	PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
	44	DRAWN								
	45	APPROVED								
REDRAWN FROM D2012-111	REV. B	DESCRIPTION OF CHANGE	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODES	DIA DASH NO. M=HEAD NEAR SIDE F=HEAD FAR SIDE	CONTRACT NO.	DART	DART AERO ACCESSORIES INC. VANCOUVER	CANADA
			GENERAL	UNITS						
			1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS .017 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER IN. 5 - .7742 5. HOLES PER IN. 10387		1 TOLERANCES - .002 .010 2 ANGLES .0075 3 PARALLELISM .0075 4 ECCENTRICITY .005 MAX 5 SYMMETRY ABOUT ALL M/C CENTRE LINES .005	04=DIMPLE 05=DIA 06=NO OF SHEETS 07=COUNTERSINK 08=SPOTWELD	DRAWS: <u>HATTON</u> 06/03/92 DESIGN: <u>BRADLEY</u> 90/9/31 STRESS: <u></u> CHECKED: <u>BRADLEY</u> 90/9/8 CLIENT: <u></u>			
			REPORT ALL DISCREPANCIES - DO NOT SCALE					COOK	DWG NO. D2012-111	REV. A
								SCALE	SH. 1 / OF 1	